

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claims 1-20 (Canceled)

21. (Currently Amended) A method of ~~cutting~~ ~~machining~~ a cast iron ~~workpiece~~,
the method comprising:

~~comprising using the insert of claim 9~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μ m, an alumina layer adjacent said first layer, the alumina layer including α -Al₂O₃ and having a thickness of from about 1 to about 15 μ m, a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μ m, and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ -Al₂O₃ and κ -Al₂O₃, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μ m;

contacting the coated cemented carbide body insert to the cast iron workpiece; and
removing a portion of the cast iron workpiece in a turning operation.

22. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:

~~using the insert of claim 9~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm , an alumina layer adjacent said first layer, the alumina layer including $\alpha\text{-Al}_2\text{O}_3$ and having a thickness of from about 1 to about 15 μm , a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm , and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of $\gamma\text{-Al}_2\text{O}_3$ and $\kappa\text{-Al}_2\text{O}_3$, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm :

contacting the coated cemented carbide body insert to the steel workpiece;
and

removing a portion of the steel workpiece in a turning operation.

23. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:
~~using the insert of claim 10~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm , an alumina layer adjacent said first layer, the alumina layer including κ -Al₂O₃ and having a thickness of from about 1 to about 15 μm , a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboxynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm , and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of γ -Al₂O₃ and κ -Al₂O₃, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm :

contacting the coated cemented carbide body insert to the steel workpiece;
and
removing a portion of the steel workpiece in a turning operation.

24. (Currently Amended) A method of ~~cutting~~ machining a steel workpiece, the method comprising:

~~using the insert of claim 11~~

providing a coated cemented carbide body insert, the coated cemented carbide body insert including a cemented carbide body, a first layer adjacent the cemented carbide body, the first layer including Ti(C,N) and having a thickness of from about 3 to about 20 μm , an alumina layer adjacent said first layer, the alumina layer including a multilayer of $\alpha\text{-Al}_2\text{O}_3$ and $\kappa\text{-Al}_2\text{O}_3$, the multilayer of from about 4 to about 150 layers and having a thickness of from about 1 to about 15 μm , a further layer adjacent the alumina layer, the further layer including a carbide, carbonitride or carboynitride of one or more of Ti, Zr and Hf, the further layer having a thickness of from about 1 to 15 μm , and a friction-reducing layer adjacent to the further layer, the friction-reducing layer including one or more of $\gamma\text{-Al}_2\text{O}_3$ and $\kappa\text{-Al}_2\text{O}_3$, wherein the friction-reducing layer has a thickness of from about 1 to about 5 μm :

contacting the coated cemented carbide body insert to the steel workpiece;
and

removing a portion of the steel workpiece in a turning operation.

25. (Canceled)

26. (New) The method of claim 21, wherein the alumina layer consists essentially of α -Al₂O₃.

27. (New) The method of claim 22, wherein the alumina layer consists essentially of α -Al₂O₃.

28. (New) The method of claim 23, wherein the alumina layer consists essentially of κ -Al₂O₃.